

Push



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4422-1
Job Sheet 168518



Part No: D4422-1

Job Qty: 2 ea

Part Name: Shim



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/16/17

Job Tracking No:

Due Date: 11/24/17

Created By: Sylvie Boucher

Type: Stock

Description:

Note: D4422 REV A IPP revA 11.06.30 new issue ec verified by: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		11/23/17	0.00	0.00	Small Fab-2	Startup SF-1	MLL
100	Small Fab	2 pcs		11/23/17	0.00	0.04	Shear		MLL
110	QC	2 pcs		11/23/17	0.00	0.00	QC5		9-88
120	HandFinish	2 pcs		11/24/17	0.00	0.04	HandFinish1		2017-11-16 JLM
130	QC	2 pcs		11/24/17	0.00	0.00	QC7		38
140	Packaging	2 pcs		11/24/17	0.00	0.00	Packaging3-1	57091	SL 9-88
150	QC21-SA	2 Ea		11/24/17	0.00	0.00	QC21		

Part Op Descriptions: 100 - 1- USE SHEAR TO CUT TO SIZE AS PER DWG 2- DEBURR

DAS
21
9-88

NOV 22 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	2.13 X 1.00 M6061T6B0.125X1.00 MAT001 FM127983	0	23	0	0

Part Specifications

Specifications could not be found.

Plex 11/16/17 7:29 AM dart.boucher.sylvie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
NCR No. _____		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Large Fab ☐	Composite ☐	Supplier ☐				

Date : _____	Step #: _____	QTY Effective : _____	MRB (QS1042) Approval _____
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Description Work Order Deviation	Disposition	Completed By
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Mtg Date: 11/16/17
Job No: 168518

Start up Operation
D4422-1

PART NO:
Revision:
Operation:
Change No:

Supervisor
rification

Director
al

Root Cause		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐
Design ☐	Operator ☐	Bending ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concer ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple, ☐
Material ☐	Use for Testing ☐	Cuffs ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐
Past Expiry Date ☐	Manufacturing Process ☐	
Misidentified ☐	Past Due ☐	OTHER : _____

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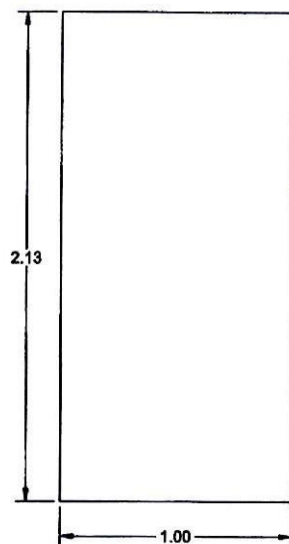
Function ☐	Misread ☐
Misaligned/off center ☐	Turning Sequence ☐

8 7 6 5 4 3 2 1

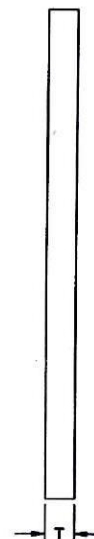
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163518

DAS
30
9-89

NOV 16 2017



D4422-X SHIM



P/N	T TH THICKNESS
D4422-1	0.125
D4422-3	0.063

NOTES:

1) MATERIAL:

D4422-1: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK, PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M8061T6S.125
OR
6061-T6/T651/T6510/T6511/T62, 0.125 X 1.000, PER QQ-A-225/8
OR AMS-QQ-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M8061T6S

D4422-3: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M8061T6S.063

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4422-X" AND B/N PER QSI 044 6.1

7) WEIGHT: D4422-1 = 0.01 lbs; D4422-3 = 0.01 lbs

RELEASED
2011-07-06

A	NEW ISSUE	MB	11.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.06.22		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A SHEET 1 OF 1	
DRAWING NO. D4422		SCALE NTS	
TITLE SHIM		COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE RELEASED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐			FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : _____					